

**\*76972\***

Thursday, November 24, 2011 1:34:40 PM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 11/24/2011    **Start Qty:** 2.00

\*2\*

**Cust Item ID:**

**Required Date:** 12/5/2011      **Req'd Qty:** 2.00

\*2\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**                      **Process Plan:**

Date: 1-11-24

### Tooling:

Date:

Stop \*NR2\*

**QC:**

Date:

**SPC (Y/N):**

Date:

<b>Sequence ID/ Work Center ID</b>	<b>Operation Description</b>	<b>Set Up/ Run Hours</b>	<b>Tool ID</b>	<b>Tool #</b>	<b>Plan Code</b>	<b>Accept Qty</b>	<b>Reject Qty</b>	<b>Reject Number</b>	<b>Insp. Stamp</b>
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
IIN-D206-559	rev L	x SP							
100		0.00							
*100*	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-559-023 CHG007			S	8/12/02/28				(2)
MLJ	12/02/28								
160	Pick Kit	0.00							
*160*									
Packaging	Memo	0.00							
Packaging									
(2x) SP	12-02-27 SD								
QC4-	100% Inspect kits for completeness	0.00							
*170*									
QC	Memo	0.00							
Quality Control				S	8/12/02/26				(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Thursday, November 24, 2011 1:35:02 PM

Work Order ID: 76972

\*76972\*

Parent Item: D206-559-023

\*D206-559-023\*

Parent Item Name: Bearpaw

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: E04.02.17Tolerance added to Step 3KJ/JLM  
 IPP Rev: F 07-01-02 Was K10006 JLM  
 IPP Rev:G 08-09-19 Added step 2 JLM Verified By:EC  
 IPP Rev:H New Manufacturing Method 08-10-29 JLM Verified By:EC  
 IPP Rev J 10.10.04 per DS19527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-17A		Purchased	No			160	Each	604.0000	12	24			
<div style="display: flex; justify-content: space-between;"> <span><i>Sr</i> *AN4-17A*</span> <span>**</span> <span>m/20187 SP. <i>sl</i></span> </div>													

Location	Loc Qty	Loc Code
ST358	4	
116419	0	
116704	0	
117619	4	
ST359	600	
118628	300	
118983	300	

AN4-20A		Purchased	No			160	Each	572.0000	12	24			
<div style="display: flex; justify-content: space-between;"> <span><i>Sr</i> *AN4-20A*</span> <span>**</span> <span>SP. <i>sl</i></span> </div>													

Location	Loc Qty	Loc Code
ST359	572	
117514	272	
118983	100	
119127	200	

AN960JD416	NAS1149D0463J	Purchased	No			160	Each	0.0000	24	48			
<div style="display: flex; justify-content: space-between;"> <span><i>Sr</i> *AN960JD416*</span> <span>**</span> <span>m/19075 SP. <i>sl</i></span> </div>													

Washer

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Thursday, November 24, 2011 1:35:02 PM

Work Order ID: 76972

**\*76972\***

Parent Item: D206-559-023

**\*D206-559-023\***

Parent Item Name: Bearpaw

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

D2182B Manufactured No

160 f

725.2542 2.5 5

**\*D2182B\***

Rubber Cushion

\*\*

SP

SP

Location

Loc Qty

Loc Code

ST410

725.25417

66063

59.94817

73932

665.306

B

(D2182B050) cut qty (6) at 5.00" as per dwg \*\*\*per kit\*\*\*

D2274 Manufactured No

160 Each

463.0000 12 24

**\*D2274\***

Radius Block

\*\*

B78589

SP

Location

Loc Qty

Loc Code

ST010

250

72121

16

73389

234

ST139

213

74435

213

D2438 Manufactured No

160 Each

229.0000 6 12

**\*D2438\***

Clamp

\*\*

B78594

SP 12-02-27

SP

Location

Loc Qty

Loc Code

ST456

229

69737

84

73400

145

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Thursday, November 24, 2011 1:35:02 PM

Work Order ID: 76972

**\*76972\***

Parent Item: D206-559-023

**\*D206-559-023\***

Parent Item Name: Bearpaw

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

D2529 Manufactured No

160 Each

792.0000 12 24

**\*D2529\***

Washer

\*\*

B79221 SP SP

Location

Loc Qty

Loc Code

ST016

792

71161

250

73486

42

76086

500

D2672 Manufactured No

160 Each

1.0000 2 4

**\*D2672\***

Bearpaw 13" X 24", 206

\*\*

B76970<sup>4x</sup> SP SP

Location

Loc Qty

Loc Code

ST495

1

73110

1

D2732 Manufactured No

160 f

392.9200 2.5 5

**\*D2732\***

Rubber Extrusion

\*\*

SP 12-02-27 SP

Location

Loc Qty

Loc Code

ST410

392.92

70987

392.92

5x

(D2732-050) cut qty (6) at 5.00" as per dwg \*\*\*per kit\*\*\*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Thursday, November 24, 2011 1:35:02 PM

Work Order ID: 76972

**\*76972\***

Parent Item: D206-559-023

**\*D206-559-023\***

Parent Item Name: Bearpaw

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

160

Each

10,757.00

12

24

**\*MS21042L4\***

\*\*

SP 12-02-27

Nut

Location

Loc Qty

Loc Code

ST300

546

117441

51

117601

362

118451

133

ST516

5211

119017

5211

ST518

5000

119075

5000

24x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 76972

**\*76972\***

Page 1

Thursday, November 24, 2011 1:34:40 PM

Item ID: D206-559-023 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearpaw  
 Start Date: 11/24/2011 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 12/5/2011 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan:                      Date: 11-11-24 Tooling:                      Date:                      Run Start **\*NR1\***  
 QC:                      Date:                      SPC (Y/N):                      Date:                      Stop **\*NR2\***


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
IIN-D206-559	rev L	<b>*SP</b>

100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-559-023 CHG007								

160	Pick Kit	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									

170	QC4- 100% Inspect kits for completeness	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

MLJ R/02/27  


## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP